



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3

Job Sheet 191176



Part No: C3

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/22/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3 Rev 2 IPP Rev A 18.03.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	External Load - 1	1 pcs	3/8/19	3/8/19	0.00	1.00	External Load - 1		
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	3/8/19	3/8/19	0.00	1.00	External Load - 1 - B4B		AP 2019/03/07
							External Load - 2 - B4B		Nickel
							External Load - 3 - B4B		
110	QC 5	1 pcs	3/8/19	3/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	DC - 1 - B4B	1 pcs	3/8/19	3/8/19	0.00	0.00	DC - 1 - B4B		
							DC - 2 - B4B		
130	Packaging 3-2 - Stock - B4B	1 pcs	3/8/19	3/8/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: \$158100



Part: C3

Job No: 191176

Serial No/Batch: \$158100

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 03/01/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS 30 33
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

19/03/12

DAS
70
9-89

Part Op 95 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2-
Descriptions: ASSEMBLE AS PER DWG

100 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2-
ASSEMBLE AS PER DWG

110 - QC5- Inspect part completeness to step on W/O)

120 - (Document Control)- Photocopy blue file OM & OOPM-C3 Rev 4

130 - Identify as per dwg & Stock Location: _____)Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Loctite 620 (M138933)

Loctite 242

Grease Aeroshell (M138724)

Saf-T-eze (M128063)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	5073061
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	5126989
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	5058851
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	5090924
8183K6	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	5118247
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	5115056-1
AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5098021-1
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5068641
C2-1-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B	5140056
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5068051
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B	5061528 5 658757
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B	5068886
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B	5046764
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B	5075123
P C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5029246
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B	5111638
C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5116487
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B	5120798
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B	5111642
C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B	5083629
C2-3-8	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5117506
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B	5072964
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5113706
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5079472
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5117910
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5080193
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5070892
P C3-12-4 80	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5125633
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5100174
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B	5072853
C3-13-1	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5072854
C3-13-4	KEEPER	1 pcs (1 ea)	100-External Load - 2 - B4B	5144330
P C3-13-5	Spring, Keeper	1 pcs (1 ea)	100-External Load - 2 - B4B	5089547
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5077290
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B	5118503
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-External Load - 2 - B4B	5117990
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B	5048430
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5128685
C3-4-1 80	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5075380
C3-4-4A	C3 Load Beam Assy	1 pcs (1 ea)	100-External Load - 2 - B4B	5151381
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	5107793
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B	5120071
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B	5137893
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B	5150351
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B	5100111
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5116296
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B	5089524
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B	5157401
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B	5075144
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B	5122088
MS21083N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B	5087938
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	5076012
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	5075329
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	5078256
NAS1149F0332P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	5050051 5103666-1
NAS1149F0363P	Washer	1 Ea (1 ea)	100-External Load - 2 - B4B	5027738
NAS1149F0463P	Washer	8 Ea (8 ea)	100-External Load - 2 - B4B	5078780
NAS1149F0632P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	5139711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	218	0
100-External Load - 2 - B4B	188-FSCS-832-5/8	4	131	0
	2595K22	1	38	0
	32446	2	804	0
	8183K6	1	36	0
	AN4-16A	3	213	0
	AN4-17A	1	247	0
	AN6-15A	1	25	0
	C2-1-1	1	1	0
	C2-10-1	1	76	0
	C2-11-2	2	64	0
	C2-3-1	2	14	0
	C2-3-10	1	6	0
	C2-3-11	1	3	0
	C2-3-2	1	0	0
	C2-3-2-1	2	20	0
	C2-3-3	1	53	0
	C2-3-3-1	1	31	0
	C2-3-5	2	81	0
	C2-3-6	1	14	0
	C2-3-8	2	24	0
	C2-5-1	1	16	0
	C3-10-2	1	31	0
	C3-11-1	1	5	0
	C3-12-1	2	41	0
	C3-12-2	1	29	0
	C3-12-3	1	11	0
	C3-12-4	1	32	0
	C3-12-5	1	10	0
	C3-12-6	2	13	0
	C3-13-1	2	34	0
	C3-13-4	1	10	0
	C3-13-5	1	99	0
	C3-2-1	1	3	0
	C3-3-4	2	30	0
	C3-3-4-1	4	101	0
	C3-3-7	1	23	0
	C3-3-9	1	66	0
	C3-4-1 - PO	2	1	0
	C3-4-4A	1	10	0
	C3-7-1	1	18	0
	C3-7-2	2	56	0
	C3-8-2	1	6	0
	C3-8-4	1	16	0
	C3-8-5	1	13	0
	C3-9-1	1	20	0
	C3-9-2	1	40	0
	EL-PLUG-M	1	32	0
	M27500-16TG2T14	1	53	0
	MS21044N4	4	148	0
	MS21083N3	2	135	0
	MS21083N6	1	119	0
	MS35266-63	2	38	0
	NAS1149F0332P	2	2,564	0
	NAS1149F0363P	1	464	0
	NAS1149F0463P	8	597	0
	NAS1149F0632P	2	415	0

Part Specifications

Specifications could not be found.

Plex 2/22/19 11:01 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							



Remote Cargo Hook Test Form

C3

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOI ENOID

NEW SOI ENOID (152951-001)

Work Order 191176

Customer 8405

Serial Number 5158100

Date 2019-3-6

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	<u>Pass</u>
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	<u>Pass</u>
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A	A	<u>Pass</u>
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A	A	<u>Pass</u>
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A	A	<u>Pass</u>
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A	A	<u>Pass</u>
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A	A	<u>Pass</u>
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A	A	<u>Pass</u>
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A	A	<u>Pass</u>
1	3,000	Manual		N/A	<u>Pass</u>
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	<u>Pass</u>
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω	<u>1.8</u> Ω	<u>Pass</u>
1	N/A	Electircal Continuity	Across both wires	N/A	<u>Pass</u>

Test Conducted By: Michel Labrde

Technician

Submit

Signature: Sylvie Sanchez
QC 5 Small FAB / QA